

SPLIT

PRELIMINARY ISSUE

Work Order ID 61938

Monday, September 13, 2010 8:17:02 AM



Page 1

Item ID: D4172-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Supporting Plate

Start Date: 9/10/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

PL

Date: 10-9-B

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4172

PA1

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

10-9-13

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61938**

Monday, September 13, 2010 8:17:02 AM



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Item ID: D4172-1

Revision ID: PRELIM

Item Name: Supporting Plate

Start Date: 9/10/2010 Start Qty: 3.00

Accept



Setup

Start



Stop



Required Date: 9/17/2010 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00 - inspected to P+1

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Day only

(x3)

8/10/09/13

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-9-14.

0.00

③ 6.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 10/09/13

0.00

X3 d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61938**

Monday, September 13, 2010 8:17:02 AM



Page 3

Item ID: D4172-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Supporting Plate

Start Date: 9/10/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: *Supporter*Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

CA

BT 10-09-23

(x2)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/29 JJ

10-09-23

POSITIVE RECALL  
 EFFECTIVE 10-09-13 AUTH J  
 RELEASED J DATE 10-09-21

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, September 13, 2010 8:17:07 AM

Page 1

Work Order ID: 61938



Parent Item: D4172-1



Parent Item Name: Supporting Plate

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		100	sf	125.2600	1.5645	4.940526			

6061-T6 .125 Sheet



Location	Loc Qty	Loc Code
MAT21	125.26	
113608	96	
114352	29.26	113608

IB10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61938
Description: SUPPORTING PLATE	Part Number:	D4172-1
Inspection Dwg: D4172-1 Rev: PM		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+.005 -.001	.129	X		V	IB62
1.500	+.010	1.498	X		V	
2.92	+.030	2.920	X		V	
1.53	+.030	1.533	X		V	
5.70	+.030	5.703	X		V	
1.23	+.030	1.228	X		V	
3.54	+.030	3.541	X		V	
5.00	+.030	4.997	X		V	
6.06	+.030	5.999	X		V	
1.000	+.010	1.003	X		V	
5.431	+.016	5.436	X		V	
1.000	+.010	1.006	X		V	
75.16	+.030	75.10	X	X	T	IB01
.435	-.010	.435	X		V	
.675	-.010	.677	X		V	
.350	+.010	.356	X		J	
.806	-.010	.796	X		V	
3.000	-.010	3.003	X		V	
5.375	+.010	5.380	X		V	
8.550	-.010	8.546	X		V	
22.085	-.010	22.085	X		T	
3.155	-.010	3.157	X		V	

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-13	Date:	10/09/13	Date:	N/A
Rev	Date	Change	inspected to Part Only	Revised by	Approved
A		New Issue		KJ/JLM	

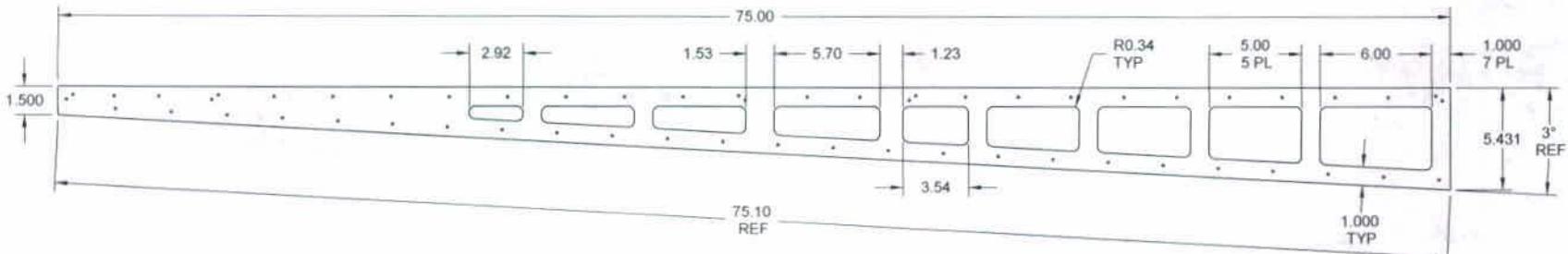
→ more

DART AEROSPACE LTD	Work Order:	61938
Description: SUPPORTING PLATE	Part Number:	D4172-1
Inspection Dwg:D4172-1 Rev: P41		Page 1 of 1

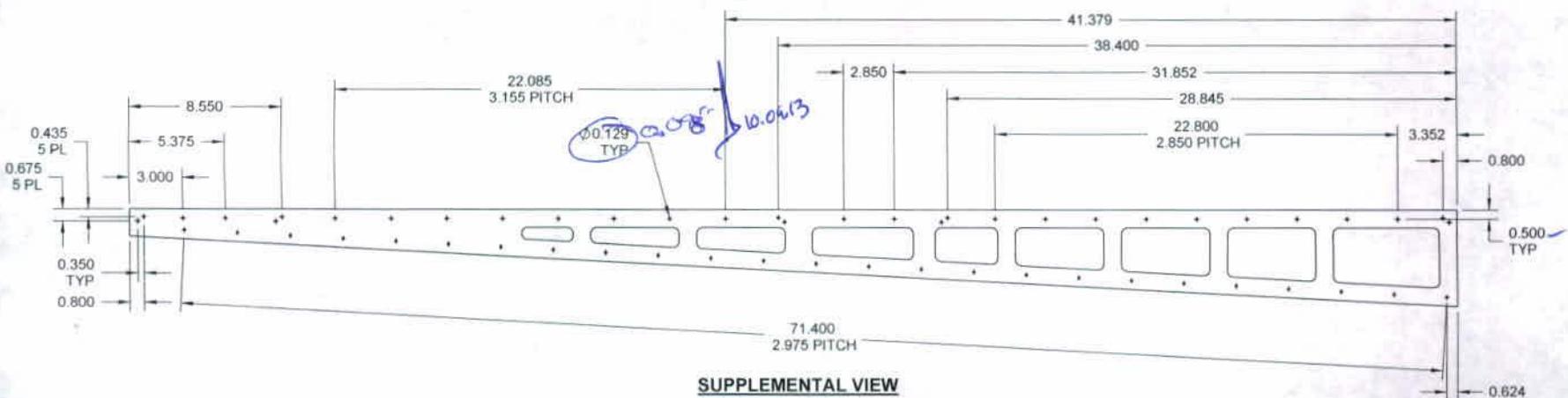
## FIRST ARTICLE INSPECTION CHECKLIST

## First Article    Prototype

Measured by:	H3	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-13	Date:	10/09/13	Date:	N/A
	inspected to part day only				



D4172-1 SUPPORTING PLATE



SUPPLEMENTAL VIEW

**PRELIMINARY ISSUE**

10.09.08

SHIPMENT  
 REFERRED TO  
 INTEGRATED  
 UNCONTROLLED COPY  
 SUBJECT TO AND RELATED  
 WITHOUT FURTHER  
 WORK ORDER  
 NO. 611938

12/10-9-B

- NOTES:**
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
  - 7) WEIGHT: 0.78 lbs

DESIGN	<i>b1</i>	DART AEROSPACE LTD
DRAWN	<i>b1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. PA1
MFG. APPR.		D4172
APPROVED		SHEET 5 OF 6
DE APPR.		TITLE POD MOUNTING FRAME ASSY NTS
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

